

1355



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V4000102-9

Job Sheet 182802



JLS

DS

DS

Part No: RBEM632V4000102-9

Job Qty: 12 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV 1 SHEET 6

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		9/5/18	0.00	0.00	Start Up Machining-3		
105	Bandsaw	12 pcs		9/5/18	0.00	0.60	Bandsaw1		
110	Mill Conv	12 pcs		9/5/18	0.00	3.00	Mill Conv 1		
120	QC	12 pcs		9/5/18	0.00	0.00	QC2 Machining-4		
130	QC	12 pcs		9/5/18	0.00	0.00	QC8 Machining-4		
140	QC	12 pcs		9/5/18	0.00	0.00	QC5		
150	Outsource	12 pcs		9/5/18			GRO002-VC	10	
160	Packaging	12 pcs		9/5/18	0.00	0.00	Packaging2		
170	QC	12 pcs		9/5/18	0.00	0.00	QC6		
180	Packaging	12 pcs		9/5/18	0.00	0.00	Packaging3-1		
190	QC21-SA	12 Ea		9/5/18	0.00	0.00	QC21		

Part Op 105 - Cut blanks to 1.0"

Descriptions: 110 - Machine as per DWG. Sheet 3

150 - Issue P/O to Groupe Altech; PO 041255 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

18/10/2
18-10-04
18-10-04
OCT 1 2 2018
9-89
OCT 1 5 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1018-A-3.000W.250	1018 Angle 3.00" X0.250" Wall	.9600 ft (.08 ea)	90-Start up Operation	508867

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1018-A-3.000W.250	1	17	0

Part Specifications

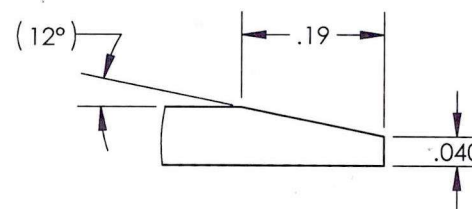
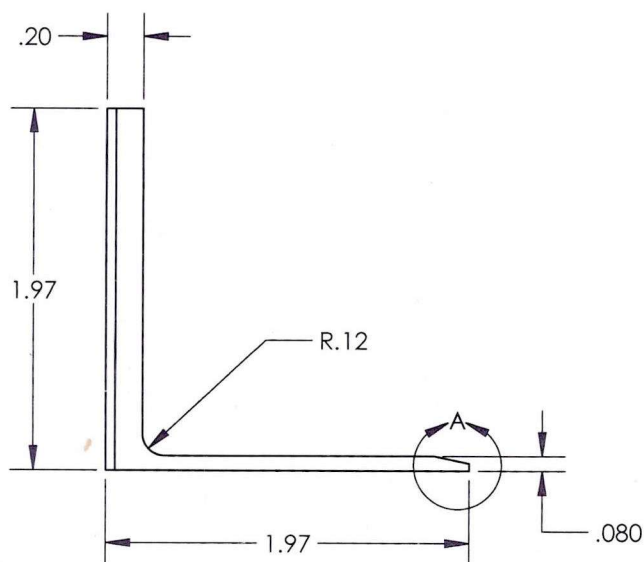
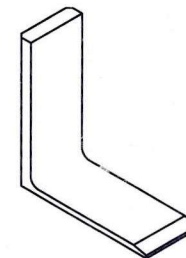
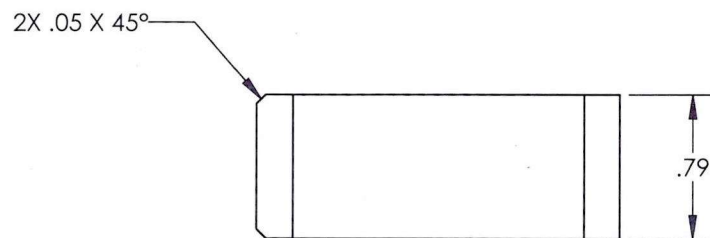
Specifications could not be found.

Plex 8/31/18 5:21 PM dart.logan.david

508867

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



DETAIL A
SCALE 4:1

(-9)

SHIM

DART AEROSPACE	
TITLE ROTOR BRAKE RIGGING SHIM	
DWG NO. RBEM632V4000102-9	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2 REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125/
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/14/2016	USED ON MODEL
SHEET 6 OF 9	H175

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulle ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

DART
 AEROSPACE
 Container No: S115196
 Part: RBEM632V4000102-9
 Job No: 182802
 Serial No/Batch: S115196
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 10/02/18

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkebury, ON K5A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



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PURCHASE ORDER **PO041258**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041258

PO Date: 10/4/18

Due Date: 10/19/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182802	RBEM632V4000102-9	Shim -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/19/18	12 pcs	0 pcs	12 pcs	\$3.5294117/pcs	\$42.35
2	179602	RBT18603-3	Modified Rod -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	10/19/18	12 pcs	0 pcs	12 pcs	\$3.5294117/pcs	\$42.35
3	179600	RBT18603-1	Handle -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/19/18	10 pcs	0 pcs	10 pcs	\$3.52941/pcs	\$35.29
Grand Total:											\$120.00

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PURCHASE ORDER PO041258

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "CL" or similar, located to the right of the A048 and A049 notes.

Plex 10/9/18 9:29 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(013281-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013281- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Oct-2018		Jessie Boisvert		041258 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V4000102-9 ✓ Rev.	SHIM 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	BLACK-OXIDE CH	12	12 ✓	0	0	0
2	RBT18603-3 ✓ Rev.	RBT18603-3 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	BLACK-OXIDE CH	12	12 ✓	0	0	0
3	RBT18603-1 Rev.	RBT18603-1 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	BLACK-OXIDE CH	10	10	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.